

Work Order ID 69900 - 2 Split

Tuesday, May 24, 2011 12:34:34 PM



Page 1

Item ID: D3943-041

Accept



Setup Start



Revision ID:

Item Name: Ground Handling Crank Assembly

Stop



Start Date: 5/24/2011 Start Qty: 5.00 ¹⁰

Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan: MUF

Date: 11-05-24 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3943

C

100

0.00



Purchasing

Memo

0.00

Issue P/O:

14152

Purchase Part Number: 8143919

Supplier: Princess Auto

Certificate of conformity is required

Description: 4000 lbs lever chain hoist

(ST169)

CL 11/05/24 (10)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Ensure material certification is attached

11/05/31 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8 11/6/31

0.00

Memo



130



Large Fab

Large Fab

Memo

1-Disassemble chain host as per dwg

2-Drill handle ass'y (D3943-051) as per dwg

0.00

0.00



EL 12-5-14

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/14

160



Powdercoat

Powder Coating

Hybrid safety Yellow 4.3.5.12

0.00

Memo

0.00

1- POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

WAS

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

190



Large Fab

Memo

0.00

Large Fab

1-Assemble as per dwg
(assy landyard CBL-1240 to CBL-460)
2- touch up with paint if necessary

200



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

1-Calibrate and tag as per dwg and QSI 008 4.4
Calibration Cert. filled out

CALIBRATION

ID D3943-041
BY S DATE 12/05/14
DUE 1 year after 1st service

18

12/05/14

12/09/14 10
EL 12.5-14 25

25

5.71/15/14

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



Packaging

Identify as per dwg & Stock Location: 169

0.00

Memo

0.00

Packaging

220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

16140/15-5

12/5/16

MF 12-05-16

W/O:		WORK ORDER CHANGES					
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Tuesday, May 24, 2011 12:34:31 PM

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 09-06-02 EC Verified By: JLM IPP Rev:B:
add DEO DD 09 11.18 verified by:JLM IPP Rev:C as per dwg
REV.C DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8143919  Lever Chain Hoist		Purchased	No			110	Each	4.0000	1	810		11/10/31	
				<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>	
				ST						4			
					68810					4			
D3943-051  Handle Assembly		Manufactured	No			180	Each	0.0000	1	810		EL 12-5-14	
				5x 78967									
D3943-053  Chain Assembly		Manufactured	No			180	Each	0.0000	1	810		EL 12-5-10	
				5x 83986									
D3943-3  Handle Extension		Manufactured	No			180	Each	3.0000	1	810		EL 12-5-14	
				7817415									
				<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>	
				ST139d						3			
					63739					3			
CBL-1240  Cable		Purchased	No			180	f	387.5000	1	810		11/09/14	
				<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>	
				ST284						387.5			
					113565					87.5			
					116438					300			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 69900

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

CBL-460

Purchased No

180

Each

86.0000

2



Loop Sleeve

Location

Loc Qty

Loc Code

ST284

86

116953

86

D3585-1

Manufactured No

180

Each

89.0000

1



Set Screw

Location

Loc Qty

Loc Code

GA

89

55705

89

D3949-041

Manufactured No

180

Each

25.0000

1



Remove before Flight Flag Assembly

Location

Loc Qty

Loc Code

ST487

25

48280

25

D3954-7

Manufactured No

180

Each

2.0000

1



Ratchet Lug

Location

Loc Qty

Loc Code

ST097

2

63738

2

AN5-11A

Purchased No

180

Each

92.0000

1



Bolt

Location

Loc Qty

Loc Code

ST337

92

117313

92

M118119

5

M119512 EL 12-5-7

80567x2
EL 12-5-10

69920x5
69920x3 EL 12-4-30

1020
EL 11-9-14

20
810

EL 11-9-21

5 + 5 EL 12-5-10
810
EL 11-9-14

10
810

EL 11-9-14

810

EL 11-9-15

5

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 69900

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

AN960-516 NAS1149F0563P Purchased No
WASHER

180 Each 70.0000 1

810

EL 11-9-15

Location

Loc Qty

Loc Code

M117735 X10

ST346

70

110098

70

MS21042L5 Purchased No
Nut

180 Each 1,243.000 1

810

EL 11-9-15

Location

Loc Qty

Loc Code

M119109 X5 EL 12-5-7

ST300

1243

116105

283

116548

260

117441

500

117591

100

117611

100

S1475 Purchased No
inventory

180 Each 9.0000 1

810

EL 11-9-15

Location

Loc Qty

Loc Code

ST396

9

113847

9

3408A59 Purchased No
BALL PLUNGER

180 Each 17.0000 1

810

EL 11-9-15

Location

Loc Qty

Loc Code

ST401

17

111948

2

113854

15

M117829 X5 EL 12-5-7

Tuesday, May 24, 2011 12:34:32 PM

Shop Packet Print

Page 3

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Page 4

Work Order ID: 69900



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Parent Item Name: Ground Handling Crank Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

HX-15

Purchased

No.

180

Each

45.0000

1



1/4-20 UNCx3/4 S.H.C.S.



810

EL 11-9-15

Location

Loc Qty

Loc Code

MEZZ

45

114383

45

HX-16

Purchased

No.

180

Each

85.0000

3



5 x 5

15 x 10

EL 11-9-15

Location

Loc Qty

Loc Code

ST390

85

117346

85

M113771

x 5
x 5

B4405-1

RA

Seq 180

Batch: B69917 x 5 EL 12-5-7

W/O:		WORK ORDER CHANGES					
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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
54	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

RELEASED
R 2011-05-24

D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED). SHT 2 ZN D3 FLAG RELOCATED. SHT 3 ZONE D3, Ø0.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. D
CHECKED		D3943	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	11.05.16		

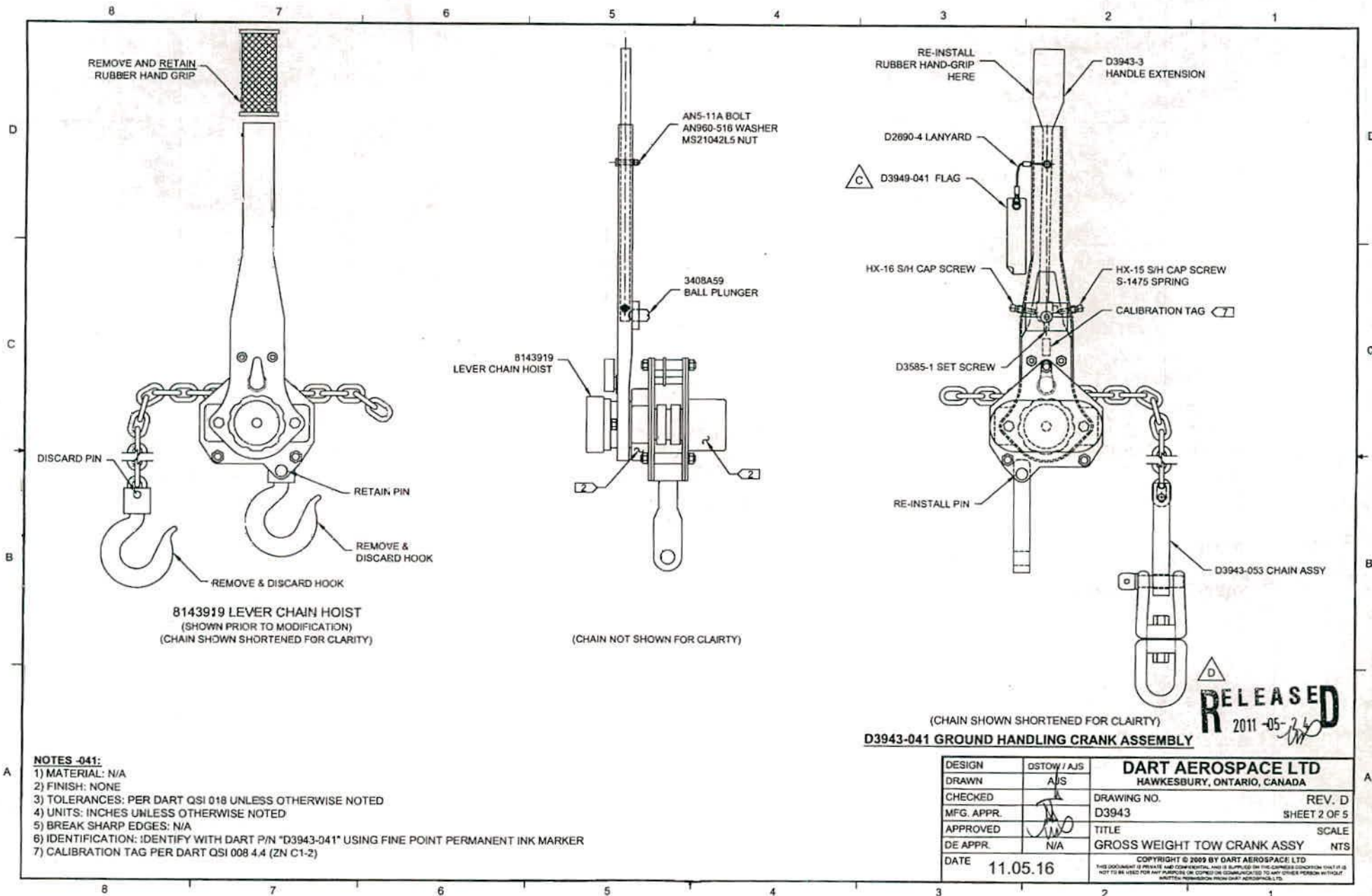
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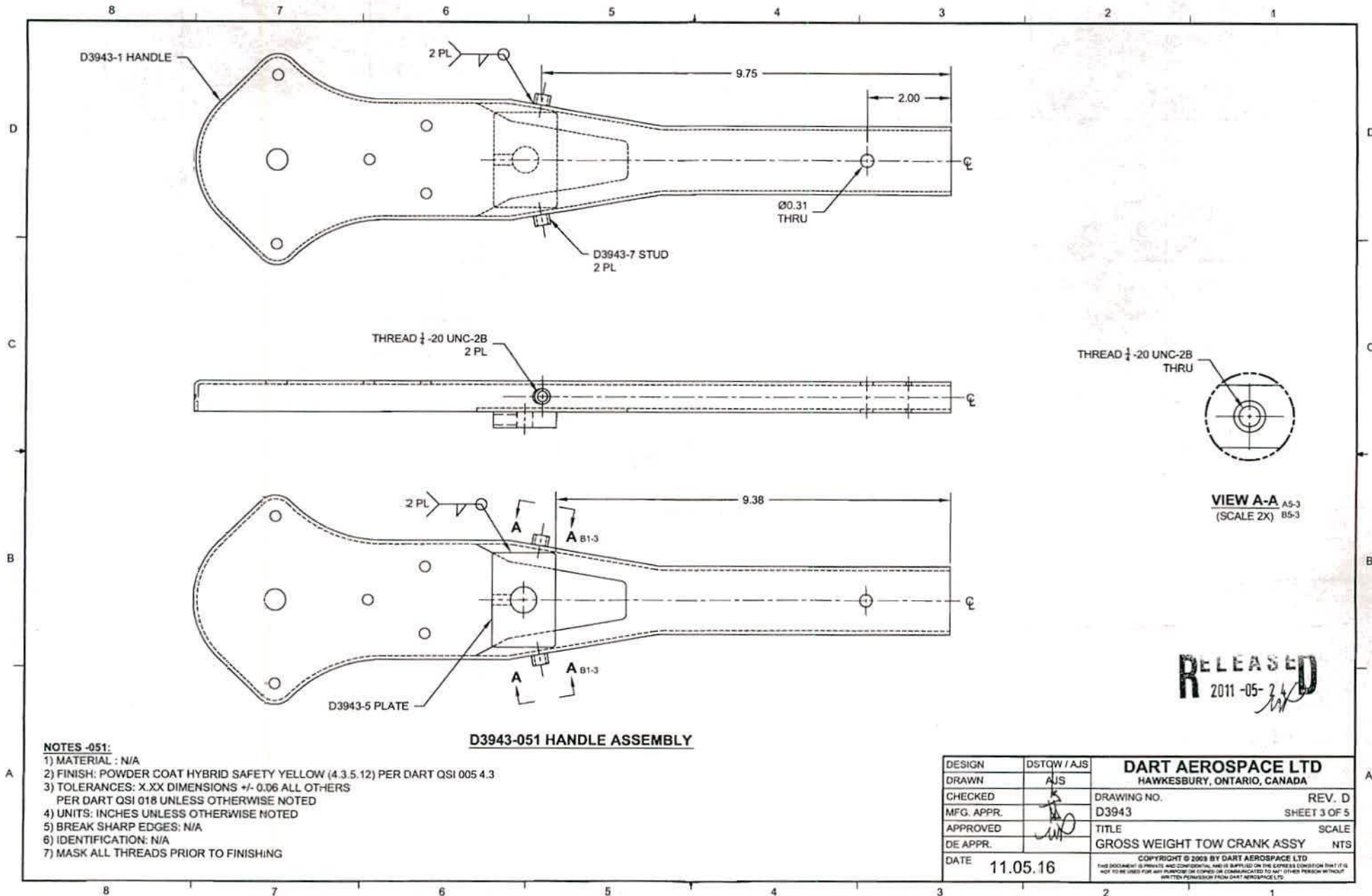
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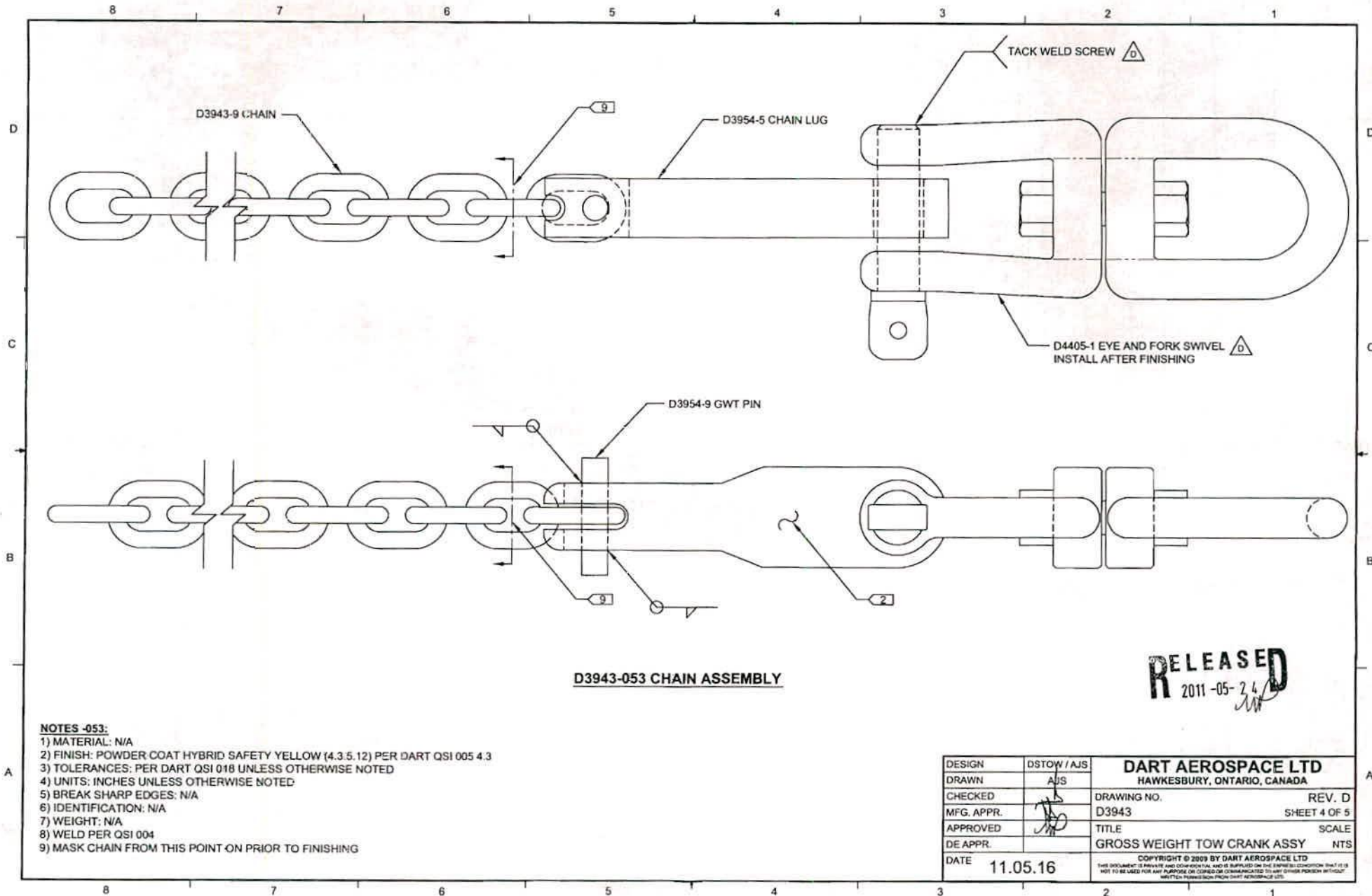
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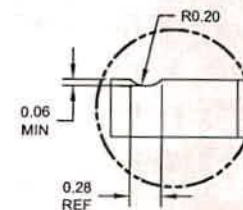
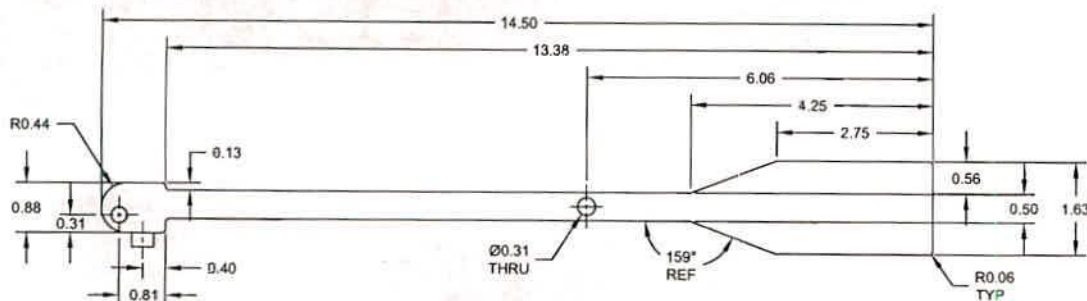
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

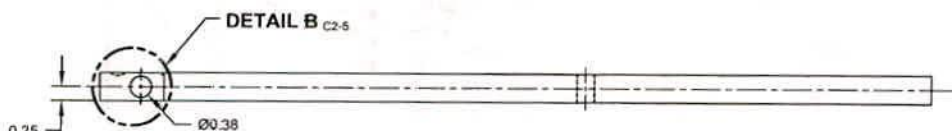
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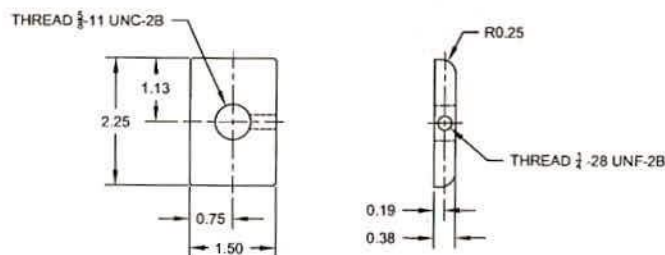
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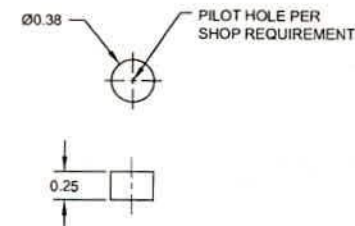
DETAIL B-B C7.5
(DIMPLE DETAIL)
(SCALE 2X)



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:

1) MATERIAL -3 & -5: MILD STEEL, SHEET

AISI 1010-1025 OR ASTM A36/A365/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR: MILD STEEL, BAR

AISI 1010-1025 OR ASTM A36/A365/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR

AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3



3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

RELEASED
2011-05-24

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.05.16	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

613 632 1053



PO Box 1005 Winnipeg, MB R3C 2W7

Phone (204) 667-4630 Fax (204) 663-7663 www.princessauto.com

A/R CHARGE

DATE	INVOICE NUMBER	ACCOUNT NUMBER	STORE NUMBER
30/05/2011 DD/MM/YY	1663072	073126	16

BILL TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

SHIP TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

QUANTITY	DESCRIPTION	UNIT PRICE	AMOUNT
5 1	B 8143919 - HOIST CHAIN 2 TON LEVER	\$159.99	\$799.95
	G 9999998 - HANDLING FEE	\$6.00	\$6.00
<p style="text-align: center;">Subtotal</p> <p style="text-align: center;">CTS: ϕ</p> <p style="text-align: center;">TR: FEDEX</p>			
		SUBTOTAL	\$805.95
		PST	\$0.00
		GST / HST	\$104.29
		TOTAL	\$910.24
		Please Pay A/R Account	\$910.24

PRINT NAME

SIGNATURE

TERMS: NET 30 DAYS.
2% PER MONTH (24% PER ANNUM COMPOUNDED MONTHLY) INTEREST ON OVERDUE ACCOUNTS.

P.O. NUMBER
14152

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FOR MORE INFORMATION VISIT www.princessauto.com/privacy
OR ASK A TEAM MEMBER.

G.S.T. REG. #R104304738

Our Royal Service Promise

NO SALE IS FINAL UNTIL YOU'RE SATISFIED!



PO Box 1005 Winnipeg, MB R3C 2W7
Phone (204) 667-4630 Fax (204) 661-0458 www.princessauto.com

A/R CHARGE

DATE	INVOICE NUMBER	ACCOUNT NUMBER	STORE NUMBER
28/05/2011 DD / MM / YY	1461917	073126	18

BILL TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

SHIP TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

QUANTITY	DESCRIPTION	UNIT PRICE	AMOUNT
5	B 8143919 - HOIST CHAIN 2 TON LEVER	\$159.99	\$799.95
1	G 9999998 - HANDLING FEE	\$6.00	\$6.00
		SUBTOTAL	\$805.95
		PST	\$0.00
		GST / HST	\$104.29
		TOTAL	\$910.24

TERMS: NET 30 DAYS.
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PO14152

Please Pay
A/R Account

\$910.24

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INTERNAL CALIBRATION CERTIFICATE

Instrument #	Description	Serial #
D3943-041	Ground Handling Crank Assembly	B69900

Calibrated by	Date of calibration	Calibrated with	Due	Certificate #
ED	May 14th, 2012	ENG-07		
		25000lbs load cell		

New tool	Disposed	In Repair	On Hold	Being Calibrated
N/A	N/A	N/A	N/A	N/A

Employee	Department	Comments:
N/A	N/A	MUST BE CALIBRATED WITH IN 1 YEAR OF PURCHASE OR FIRST OPERATION

Spec.	Tolerance is + /-	Result	Pass Fail
3500LBS	3500-3700LBS	3600lbs	PASS

Entered By:
Eric Downing QC Coordinator

ED 5/15/12

